

Work Order ID 57451

April 7, 2010 9:54:22 AM

Page 1

Item ID: D2512

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid 205/350

Start Date: 07/04/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-11-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: 1113328 0.00

Large Fab

Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-Weld as per Dwg D2512 using Welding Jig D1 9436

Deburr as required

INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

SAD 10-07-27

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

① 10/09/03 (K)

10.09.04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57451

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Page 2

Item ID: D2512

Accept



Setup

Start



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Stop



Start Date: 07/04/2010 Start Qty: 1.00



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Customer:

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Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

8120204

QC

Memo

0.00

Quality Control

TL

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

11/14/84

1ST COAT:

START TIME: 2:00

OVEN TEMPERATURE: 400°

FINISH TIME: 2:30

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 BR 10-8-4.

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandFinish

Hand Finishing

HandFinishing

Memo 1115028

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4
Batch: 1114332

0.00

0.00

10/08/05

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

160



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

G-A
W/O 57449

E/S 10/08/05 (C)

E/S 10/08/05 (C)

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Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/05

MF

10-8-05

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Picklist Print

April 7, 2010 9:54:26 AM

Page 1

Work Order ID: 57451

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Comments: Rev IPP:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF
 IPP Rev:N 06.04.05 Added level21 EC
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 07/04/2010

Start Qty: 1.00

Required Date: 16/04/2010

Required Qty: 1.00

✓ D2012-117 Manufactured No 100 Each
 Clevis

Warehouse	Loc Qty
Location	
Main Warehouse	
WA	39
52498	9
55729	30

39.0000 2.0000

Loc Code

B3091 ② 10/07/28

*** ONLY APPLICABLE ON D130-701-041 -IF
 NOT USED, PLEASE MARK N/A ***

✓ D2232-1 Manufactured No 100 Each
 Basket Hinge

Warehouse	Loc Qty
Location	
Main Warehouse	
WA	36
55791	36

36.0000 2.0000

Loc Code

10/07/28

/ D2327-1 Manufactured No 100 Each
 Spacer Bushing

Warehouse	Loc Qty
Location	
Main Warehouse	
WA	25
52832	5
54658	20

25.0000 2.0000

Loc Code

2x 10/07/28

2x

W/O:		WORK ORDER CHANGES						
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 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2506 Manufactured No 100 Each 1.0000 1.0000



Label Plate

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	1	
55700	1	

B 60272 ① SM 10/07/29

✓ D2581 Manufactured No 100 Each 15.0000 2.0000



Mounting Bracket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	15	
46086	2	
51745	2	
55918	11	

B 60198 2 SM 10/07/28

✓ D3166-3 Manufactured No 100 Each 9.0000 1.0000



Basket Hoop

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	9	
55697	3	
56426	6	

SAD 10-07-28

59266

April 7, 2010 9:54:26 AM

Shop Packet Print

Page 2

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 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F Purchased No 100 sf



Expanded Metal Flat SS

Warehouse	Loc Qty
Location	
Main Warehouse	
MAT	656.3474
111956	28
112949	12
113497	28
113555	303.45
113904	43.2132
114212	241.6842

656.3474 18.9474



SAD

10-08-04

Loc Code

M-115067 18.9474

M304TS0.750W.065 Purchased No 100 f



304 SQ Tube .75x.75x.065W

Warehouse	Loc Qty
Location	
Main Warehouse	
WA	530.2458
111148	58
113956	23.5
114137	448.7458

530.2458 45.8741



SAD

10-07-27

Loc Code

10.00
35.8741

April 7, 2010 9:54:26 AM

Shop Packet Print

Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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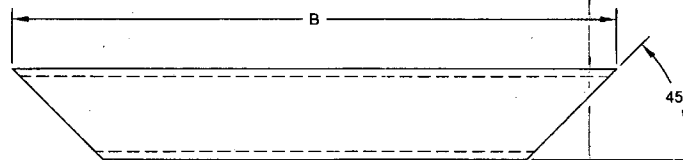
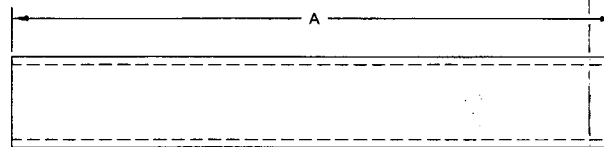
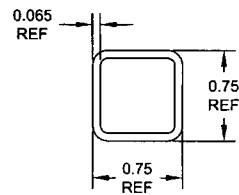
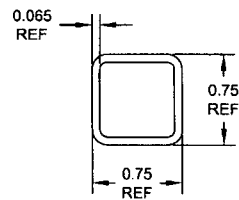
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 57451

BS10-4-07

RELEASED
08-08-21-11

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN/C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

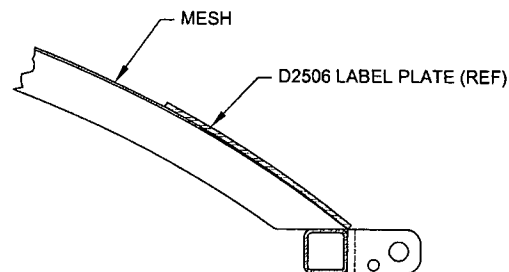
W/O:		WORK ORDER CHANGES						
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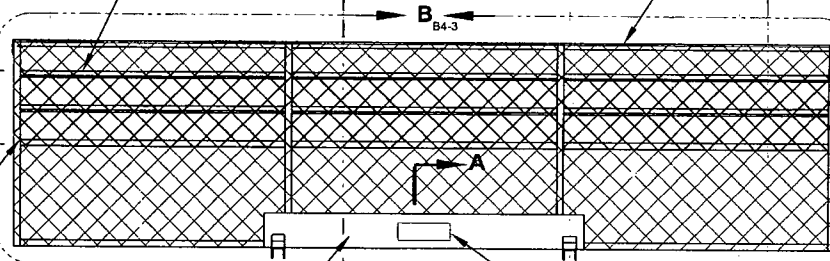
SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



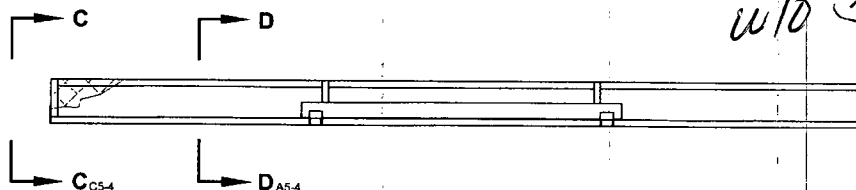
D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



u/d 57451

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

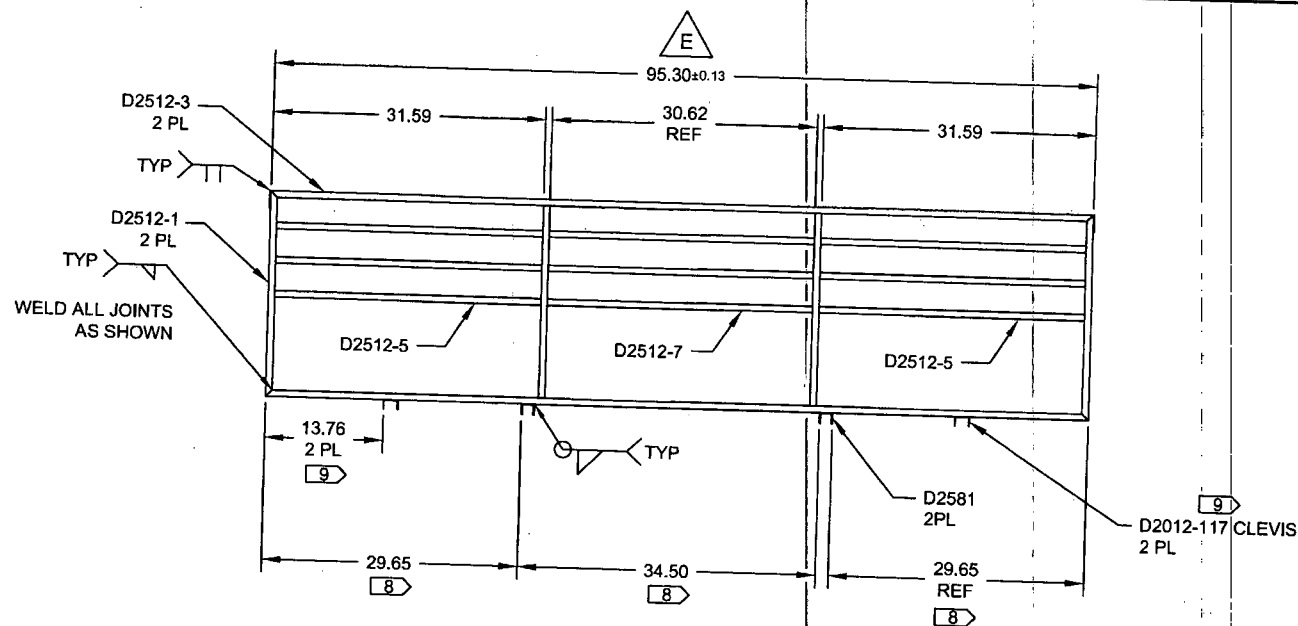
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

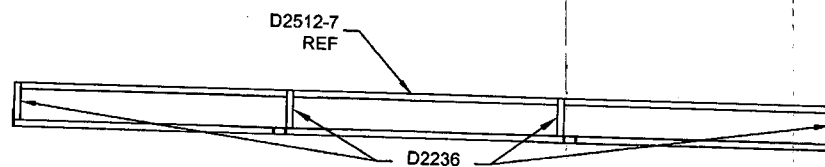
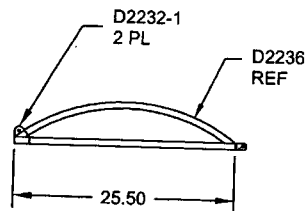
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

RELEASED
08 06 17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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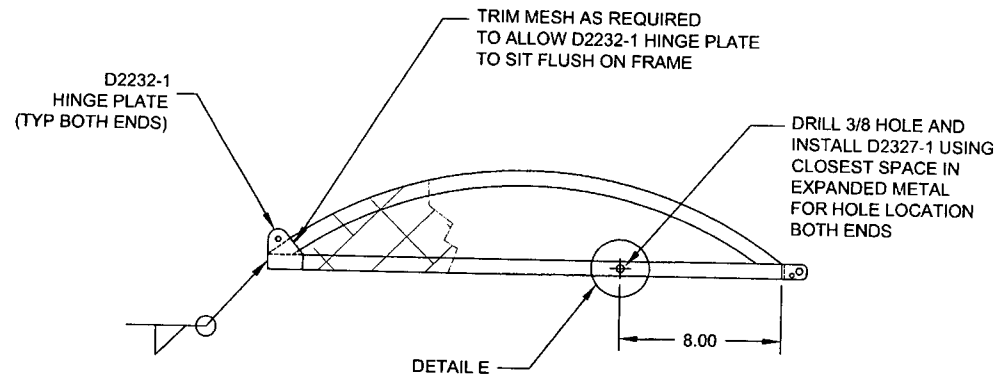
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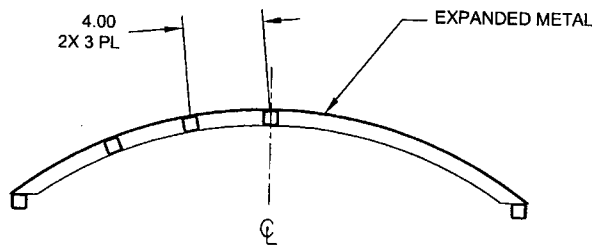
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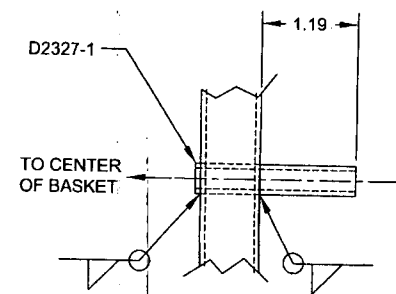
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

W/0 57451

RELEASED

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

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